

Work Order ID 67910

Monday, April 04, 2011 1:47:58 PM



Page 1

Item ID: D4030-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 11-04-04 Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4030 | C |

| | | |
|-----|----------|------|
| 100 | Pick Kit | 0.00 |
|-----|----------|------|



| | | |
|-----------|------|------|
| Packaging | Memo | 0.00 |
|-----------|------|------|

Packaging

SD 11/04/13 ①

| | | |
|-----|---------------------|------|
| 110 | Assemble as per dwg | 0.00 |
|-----|---------------------|------|



| | | |
|------------|------|------|
| HandFinish | Memo | 0.00 |
|------------|------|------|

Hand Finishing

E 5/11/04/13 ①

| | | |
|-----|---|------|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 |
|-----|---|------|



| | | |
|----|------|------|
| QC | Memo | 0.00 |
|----|------|------|

Quality Control

M 11 04 13 ①

Work Order ID 67910

Monday, April 04, 2011 1:47:59 PM



Page 2

Item ID: D4030-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP 67889

0.00

Packaging

4/4/13

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/4/14

MF

11-04-13

Picklist Print

Monday, April 04, 2011 1:47:48 PM

Page 1

Work Order ID: 67910

Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)





Start Date: 4/4/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C added
NAS1149F0332P & NAS1149C0432R 10.06.16 DD
VERF:EC IPP Rev:D as per
dwg revC DD 10.08.18 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D2530  Handle Weldment | | Manufactured | No | | | 100 | Each | 13.0000 | 1 | 1 | | 11/04/13 | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | ST506 | | | 13 | | | | | | |
| | | | | 66171 | | | 5 | | | | | | |
| | | | | 66563 | | | 8 | | | | | | |
| D2535  Spring | | Manufactured | No | | | 100 | Each | 65.0000 | 2 | 2 | | 11/04/13 | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | ST504 | | | 65 | | | | | | |
| | | | | 64280 | | | 11 | | | | | | |
| | | | | 66764 | | | 54 | | | | | | |
| D2537  Bushing | | Manufactured | No | | | 100 | Each | 58.0000 | 2 | 2 | | 11/04/13 | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | ST504 | | | 58 | | | | | | |
| | | | | 65077 | | | 16 | | | | | | |
| | | | | 66972 | | | 42 | | | | | | |
| D3913-041  Long Basket Base Assembly, 350 | | Manufactured | No | | | 100 | Each | 0.0000 | 1 | 1 | | 11/04/13 | |

B 67911

Picklist Print

Monday, April 04, 2011 1:47:48 PM

Work Order ID: 67910



Parent Item: D4030-043



Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 4/4/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|---------------------------------|--------------|----|-----|------|---------|---|---|
| D3915-041 | Manufactured | No | 100 | Each | 0.0000 | 1 | 1 |
| | | | | | | | |
| Light Lid Assembly, Long Basket | | | | | | | |
| D3917-3 | Manufactured | No | 100 | Each | 20.0000 | 6 | 6 |
| | | | | | | | |
| Washer | | | | | | | |

B 6804

SB 11/04/13

SB 11/04/13

Location

Loc Qty

Loc Code

ST092

20

66903

20

6

| | | | | | | | |
|----------------------|--------------|----|-----|------|--------|---|---|
| D3953-3 | Manufactured | No | 100 | Each | 0.0000 | 2 | 2 |
| | | | | | | | |
| Gas Spring Stud, Lid | | | | | | | |
| D3953-7 | Manufactured | No | 100 | Each | 7.0000 | 2 | 2 |
| | | | | | | | |
| Spring Spacer | | | | | | | |

B 6789

SB 11/04/13

SB 11/04/13

Location

Loc Qty

Loc Code

ST096

7

65053

4

65621

3

1

| | | | | | | | |
|-------------------|--------------|----|-----|------|---------|---|---|
| D3953-9 | Manufactured | No | 100 | Each | 16.0000 | 2 | 2 |
| | | | | | | | |
| Gas Spring Washer | | | | | | | |

B 67860

SB 11/04/13

Location

Loc Qty

Loc Code

ST089

16

66162

16

2

Picklist Print

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Page 3

Work Order ID: 67910

Parent Item: D4030-043


Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 4/4/2011

Required Date: 4/15/2011


Start Qty: 1.00

Required Qty: 1.00

D3953-17 Manufactured No 100 Each 8.0000 2 2

 Gas Spring Spacer


Location Loc Qty Loc Code

ST096 8
 65138 8

D3953-19 Manufactured No 100 Each 9.0000 1 1

 Gas Spring Bracket


Location Loc Qty Loc Code

ST096 9
 59213 1
 64810 8

D3953-21 Manufactured No 100 Each 8.0000 1 1

 Gas Spring Bracket


Location Loc Qty Loc Code

ST096 8
 66110 8

D3969-3 Manufactured No 100 Each 4.0000 1 1

 Spring (Basket Lid)

Location Loc Qty Loc Code

ST272 4
 64285 4

AN3-14A Purchased No 100 Each 23.0000 4 4

 Bolt

Location Loc Qty Loc Code

ST351 23
 116978 23

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Shop Packet Print

Page 3

Picklist Print

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Page 4

Work Order ID: 67910

Parent Item: D4030-043



Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 4/4/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|--|-----------|----|-----|------|---------|---|-------------|
| AN3-20A | Purchased | No | 100 | Each | 40.0000 | 2 | 2 |
|  | | | | | |  | 88 11/04/13 |
| Bolt | | | | | | | |
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Shop Packet Print

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Picklist Print

Monday, April 04, 2011 1:47:49 PM

Page 5

Work Order ID: 67910

Parent Item: D4030-043



Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 4/4/2011

Required Date: 4/15/2011



Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|--|-----------|----|-----|------|---------|---|-------------|
| AN310C4 | Purchased | No | 100 | Each | 34.0000 | 2 | 2 |
|  | | | | | |  | SA 11/04/13 |
| Nut | | | | | | | |



| | | |
|-----------------|----------------|-----------------|
| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|

| | | |
|--------|----|---|
| ST324 | 34 | |
| 116741 | 34 | 2 |

| | | | | | | | |
|--|-----------|----|-----|------|-----------|---|-------------|
| MS21042L3 | Purchased | No | 100 | Each | 2,074.000 | 6 | 6 |
|  | | | | | |  | SB 11/04/13 |
| Nut | | | | | | | |



| | | |
|-----------------|----------------|-----------------|
| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|

| | | |
|--------|------|---|
| ST300 | 2074 | |
| 116391 | 474 | 6 |
| 116540 | 800 | |
| 116549 | 800 | |

| | | | | | | | |
|--|-----------|----|-----|------|----------|---|-------------|
| MS21042L5 | Purchased | No | 100 | Each | 861.0000 | 4 | 4 |
|  | | | | | |  | SB 11/04/13 |
| Nut | | | | | | | |

| | | |
|-----------------|----------------|-----------------|
| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|

| | | |
|--------|-----|---|
| ST300 | 861 | |
| 115594 | 101 | 4 |
| 116105 | 500 | |
| 116548 | 260 | |

| | | | | | | | |
|--|-----------|----|-----|------|----------|---|-------------|
| MS24665-151 | Purchased | No | 100 | Each | 517.0000 | 3 | 3 |
|  | | | | | |  | SB 11/04/13 |
| Cotter Pin | | | | | | | |

| | | |
|-----------------|----------------|-----------------|
| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|

| | | |
|-------|-----|---|
| ST309 | 517 | |
| 17566 | 517 | 3 |

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Shop Packet Print

Page 5

Picklist Print

Monday, April 04, 2011 1:47:49 PM

Work Order ID: 67910

Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 4/4/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

98.0000

2

2



Cotter Pin



SB 11/04/13

Location

Loc Qty

Loc Code

ST309

98

116823

98

2

NAS1149F0432P

Purchased

No

100

Each

0.0000

6

6



Washer



SB 11/04/13

NAS1149F0563P

Purchased

No

100

Each

89.0000

4

4



Washer



SB 11/04/13

Location

Loc Qty

Loc Code

ST275

89

114576

89

4

NAS1149F0332P

Purchased

No

100

Each

22.0000

8

8



WASHER



SB 11/04/13

Location

Loc Qty

Loc Code

ST275

22

18057

22

8

NAS1149C0432R

Purchased

No

100

Each

1,614.000

2

2



Washer



SB 11/04/13

Location

Loc Qty

Loc Code

ST297

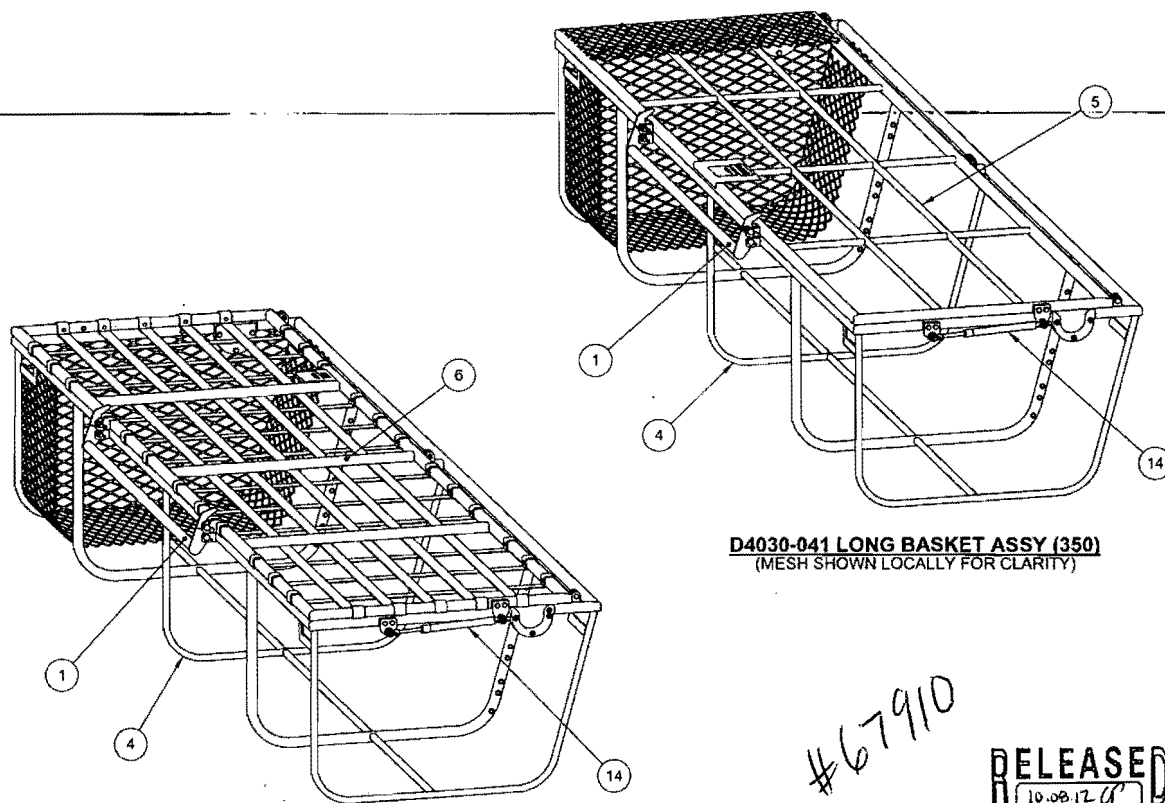
1614

116900

1614

2

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|---------------|-----------------------------------|
| | X | | D4030-041 | LONG BASKET ASSY (350) |
| | | X | D4030-043 | LONG BASKET ASSY, LIGHT LID (350) |
| 1 | 1 | 1 | D2530 | HANDLE WELDMENT |
| 2 | 2 | 2 | D2535 | SPRING |
| 3 | 2 | 2 | D2537 | BUSHING |
| 4 | 1 | 1 | D3913-041 | LONG BASKET BASE ASSY (350) |
| 5 | 1 | | D3914-041 | LONG BASKET LID ASSY (350) |
| 6 | | 1 | D3915-041 | LIGHT LID ASSY-LONG BASKET |
| 7 | 6 | 6 | D3917-3 | WASHER |
| 8 | 2 | 2 | D3953-3 | GAS SPRING STUD, LID |
| 9 | 2 | 2 | D3953-7 | GAS SPRING SPACER |
| 10 | 2 | 2 | D3953-9 | GAS SPRING WASHER |
| 11 | 2 | 2 | D3953-17 | GAS SPRING SPACER |
| 12 | 1 | 1 | D3953-19 | GAS SPRING BRACKET |
| 13 | 1 | 1 | D3953-21 | GAS SPRING BRACKET |
| 14 | 1 | 1 | D3969-3 | SPRING |
| 15 | 4 | 4 | AN3-14A | BOLT |
| 16 | 2 | | AN3-16A | BOLT |
| 17 | | 2 | AN3-20A | BOLT |
| 18 | 3 | 3 | AN4-12 | BOLT (DRILLED) |
| 19 | 4 | 2 | AN5-17A | BOLT |
| 20 | | 2 | AN5-21A | BOLT |
| 21 | 3 | 3 | AN310-4 | NUT, CASTELLATED |
| 22 | 2 | 2 | AN310C4 | NUT, CASTELLATED |
| 23 | 6 | 6 | MS21042L3 | NUT |
| 24 | 4 | 4 | MS21042L5 | NUT |
| 25 | 3 | 3 | MS24665-151 | COTTER PIN |
| 26 | 2 | 2 | MS24665-300 | COTTER PIN |
| 27 | 6 | 6 | NAS1149F0432P | WASHER |
| 28 | 4 | 4 | NAS1149F0563P | WASHER |
| 30 | 8 | 8 | NAS1149F0332P | WASHER |
| 31 | 2 | 2 | NAS1149C0432R | WASHER |



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

| | | | |
|------------|--|-----|----------|
| C | QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B9-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3). | MB | 10.07.23 |
| B | AN5-21A BOLT WAS AN5-19A: BOM & (D3-3) | JPH | 10.04.06 |
| A | NEW ISSUE | JPH | 10.03.18 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | ALs | | |
| DRAWN | JP | | |
| CHECKED | JFS | | |
| MFG. APPR. | JFS | | |
| APPROVED | JFS | | |
| DE APPR. | JFS | | |
| DATE | 10.07.23 | | |

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4030**

TITLE **LONG BASKET ASSY (350)**

SCALE **NTS**

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RELEASED
10.08.17
ECN 10-596

#67910

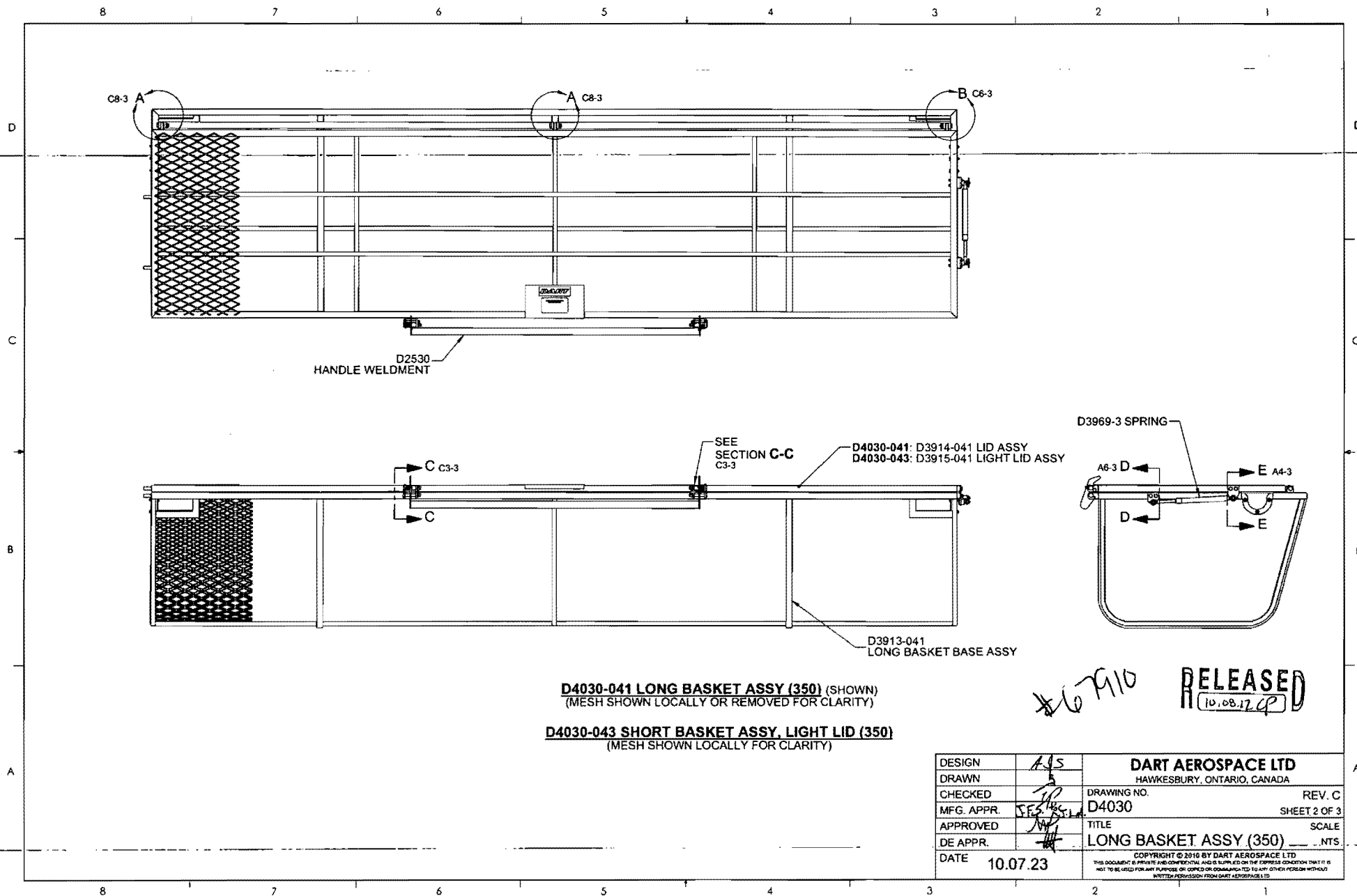
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

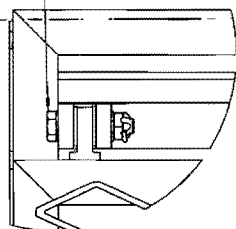
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

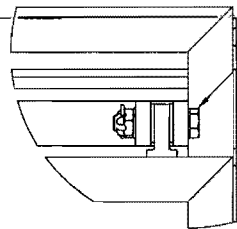
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



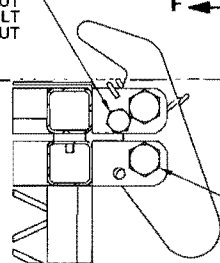
DETAIL A D8-2
D5-2



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

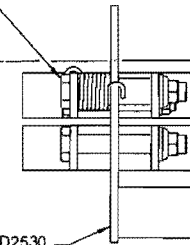
D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

#67910

RELEASED
10.08.124

| | | | |
|------------|----------|---|-----------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4030 | REV. C |
| MFG. APPR. | JFS | SHEET 3 OF 3 | |
| APPROVED | | TITLE LONG BASKET-ASSY (350) | SCALE NTS |
| DE APPR. | | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries